

**Work Order ID 62351**

September 28, 2010 10:12:18 AM

**PRELIMINARY ISSUE**

Page 1

Item ID: D4203-3

Accept



Setup Start



Revision ID: PRELIM

Item Name: Cover

Stop



Start Date: 29/09/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 04/10/2010 Req'd Qty: 1.00



Customer:

Reference:

*10.09.28*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D4203

PA1

100

0.00



Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK TO 4.370" LONG

0.00

*SL 10/09/29**①*

110

0.00



HAAS 1

HAAS CNC vertical machine #1

Memo

MILL AS PER DWG AND FOLIO FA 973

FOLIO REV: *AA*DWG REV: *PA1*

0.00

*SL 10/09/29**①*

DEBURR

**Work Order ID 62351**

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Page 2

Item ID: D4203-3

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Revision ID: PRELIM

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Item Name: Cover

Start Date: 29/09/2010 Start Qty: 1.00



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Required Date: 04/10/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

SL 10/09/29



QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

Jen/10.09.29



QC

Memo

0.00

①

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

HL 10/10/01



HandFinish

Memo

0.00

1

8

Hand Finishing

# Work Order ID 62351

September 28, 2010 10:12:18 AM



Page 3

Item ID:	D4203-3	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Cover					
Start Date:	29/09/2010	Start Qty: 1.00		Cust Item ID:		
Required Date:	04/10/2010	Req'd Qty: 1.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  Powdercoat Powder Coating	Fire Red(Ref:4.3.5.10) per QSI005 4.3 <i>M 102391 START 2:00</i> <i>QWENT. 320°</i> <i>FINISH 2:30</i>	0.00 <i>BR 10-10-H.</i>							
	Memo	0.00			①				
160  QC Quality Control	QC3- Inspect Part Finish	0.00 <i>=&gt; 10/10/05</i>				1	0		
	Memo	0.00							
170  Packaging Packaging	Identify as per dwg & Stock Location: <i>G.A</i>	0.00							
	Memo	0.00							

*10/10/05* ①

**Work Order ID 62351**

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Page 4

Item ID: D4203-3

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Cover

Start Date: 29/09/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 04/10/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 10/09/30

RELEASED

AUTH

DATE

10/10/10

u 10-10-05

# Picklist Print

September 28, 2010 10:12:17 AM

Page 1

Work Order ID: 62351

Parent Item: D4203-3

Parent Item Name: Cover



Start Date: 29/09/2010

Required Date: 04/10/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 10-09-28 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X02.50 0		Purchased	No				f	113.8002	0.365	0.384211			



6061-T6 Bar 1.50 x 2.50



2L 10/09/29

Location

Loc Qty

Loc Code

MAT10

113.8002105

103069

12

107387

61

16716

4.8002105

16742

36

39

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 62351
<b>Description:</b> COVER		<b>Part Number:</b> D4203-3
<b>Inspection Dwg:</b> D4203 <b>Rev:</b> PA1		<b>Page 1 of 2</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.50	+ .030	1.499	✓		Vern JL-3	
.450	+ .010	.449	✓		"	
.720	+ .010	.718	✓		"	
4.25	+ .030	4.250	✓		"	
3.600	+ .010	3.598	✓		"	
2.161	+ .010	2.161	✓		"	
1.000	+ .010	.999	✓		"	
.25	+ .030	.244	✓		"	
.850	+ .010	.852	✓		H-G	
1.081	+ .010	1.081	✓		Vern JL-3	
2.125	+ .010	2.125	✓		"	
5.188	+ .010	.188	✓		R-G	
.300	+ .010	.300	✓		Vern JL-3	
.635	+ .010	.636	✓		"	
1.250 X .715	+ .010	1.248 X .711	✓		"	
Ø.185	+ .005	.186	✓		"	
.456	+ .010	.446	✓		"	
1.900	+ .010	1.898	✓		"	
.750	+ .010	.750	✓		"	
2.763	+ .010	2.763	✓		"	
1.798	+ .010	1.797	✓		"	
.430	+ .010	.430	✓		"	
1.175	+ .010	1.174	✓		"	

<b>Measured by:</b>		<b>Audited by:</b>		<b>Prototype Approval:</b>	N/A
<b>Date:</b>		<b>Date:</b>		<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



8 7 6 5 4 3 2 1

D

D

Qty. -041	Qty. -051	PART NUMBER	DESCRIPTION
X		D4203-041	TAIL ROTOR DISABLING KIT
1	X	D4203-051	PEDAL LOCK
	1	D4203-1	BASE
	1	D4203-3	COVER
	1	D3373-5	CAM LOCK ASSY
	1	D3385-3	HINGE
	2	Ø3/16 X 0.50 GROUND STUD DOWEL PIN	GROUND STUD DOWEL PIN
	4	AN526C832R6	SCREW
	1	D3370-5b	

w/o 62351

C

C

B

B

PRELIMINARY ISSUE  
10.09.24  
MP

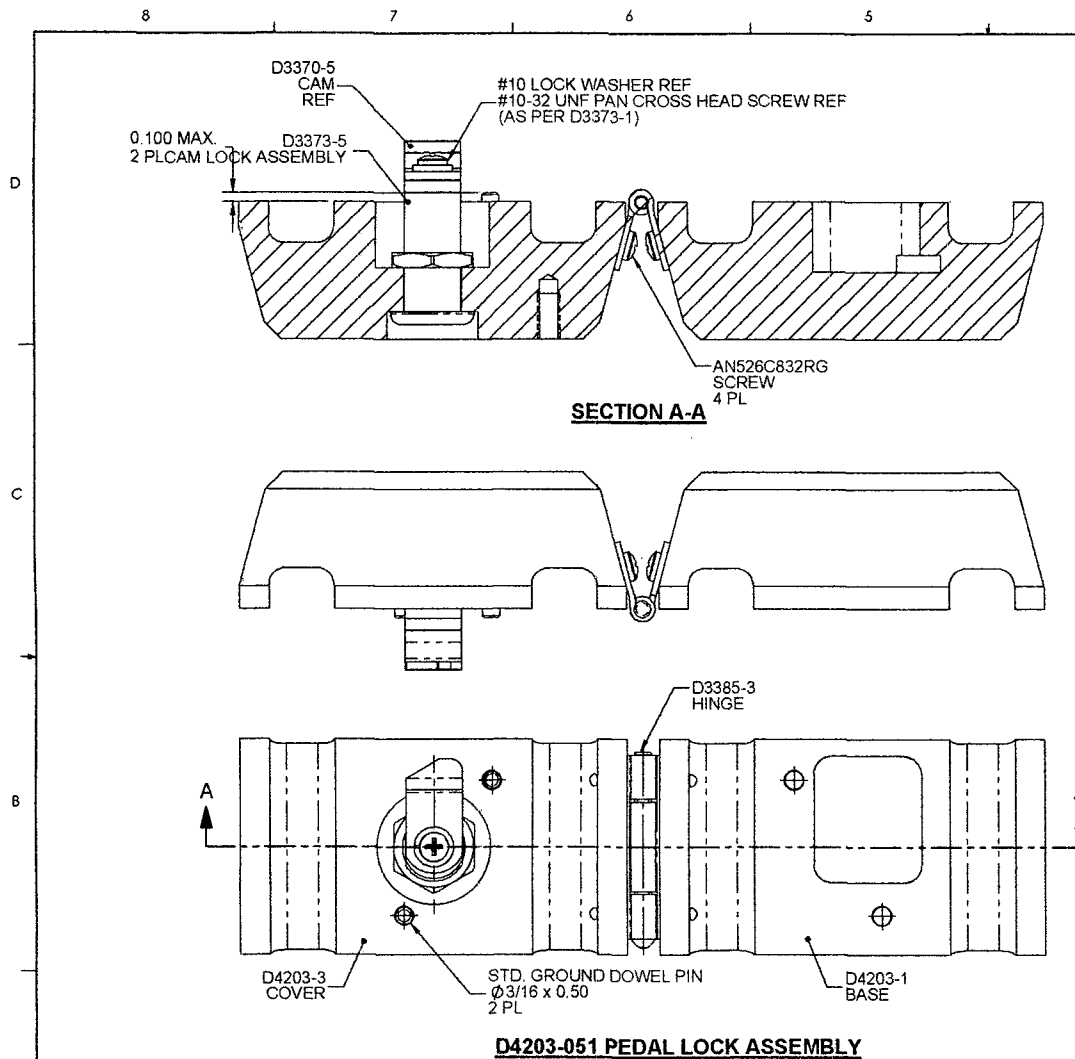
A

A

A	NEW ISSUE	MP	10.09.27
REV.	DESCRIPTION	BY	DATE
DESIGN	MP	DART AEROSPACE LTD	
DRAWN	MP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4203	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		PEDAL LOCK	NTS
DATE	10.09.27	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR LOANED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



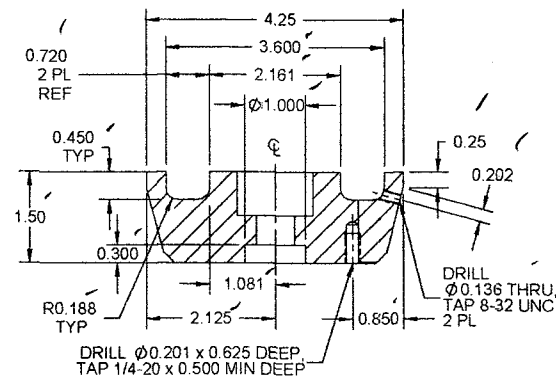
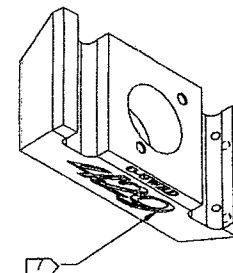


**NOTES:**

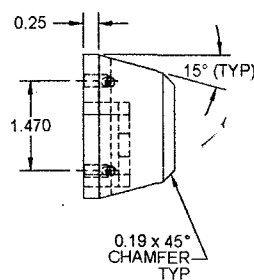
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.75 lbs

PRELIMINARY ISSUE  
10.09.24  
MP

DESIGN	MP	<b>DART AEROSPACE LTD</b>	
DRAWN	MP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		<b>D4203</b>	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>PEDAL LOCK</b>	NTS
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**SECTION C-C**



Technical drawing of a mechanical part, likely a bush or sleeve, showing dimensions and tolerances. The part is cylindrical with a central hole and a smaller hole. Dimensions include diameters, lengths, and chamfers.

Key dimensions and features:

- Overall length: 2.763
- Overall diameter:  $\phi 1.250 \times 0.715$  DEEP
- Inner diameter:  $\phi 0.750^{+0.010}_{-0.000}$
- Small hole diameter:  $\phi 0.185$  (#13 DRILL)  $\times 0.456$  DEEP
- Chamfer:  $0.015 \times 60^\circ$  CHAMFER 2 PL
- Length of small hole: 0.430
- Length of main body: 1.798
- Overall diameter of main body: 1.900
- Length of main body from center: 1.175
- Length of main body from end: 0.635
- Length of main body from end: 2.35

w/o 62351

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
REF. DART SPEC. M6061T6B
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 7) ENGRAVE LOGO AND AIRCRAFT ID PER D4203-3.SLOPRT

DESIGN	MP	<b>DART AEROSPACE LTD</b>	
DRAWN	MP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA 1
MFG. APPR.		D4203	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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Qty. -041	Qty. -051	PART NUMBER	DESCRIPTION
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	1	D4203-3	COVER
	1	D3373-5	CAM LOCK ASSY
	1	D3385-3	HINGE
	2	Ø 3/16 X 0.50 GROUND STUD DOWEL PIN	GROUND STUD DOWEL PIN
	4	AN526C832R6	SCREW

62351

RELEASED  
R 2010-10-15 D  
MP

A	NEW ISSUE	MP	10.10.15
REV.	DESCRIPTION	BY	DATE
DESIGN	MP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MP		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4203	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	PEDAL LOCK	NTS
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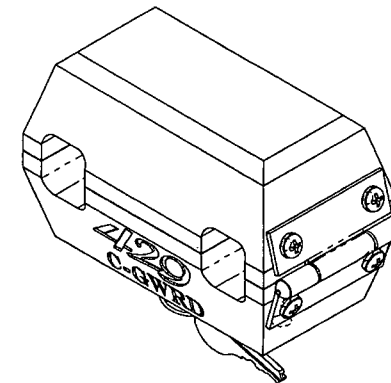
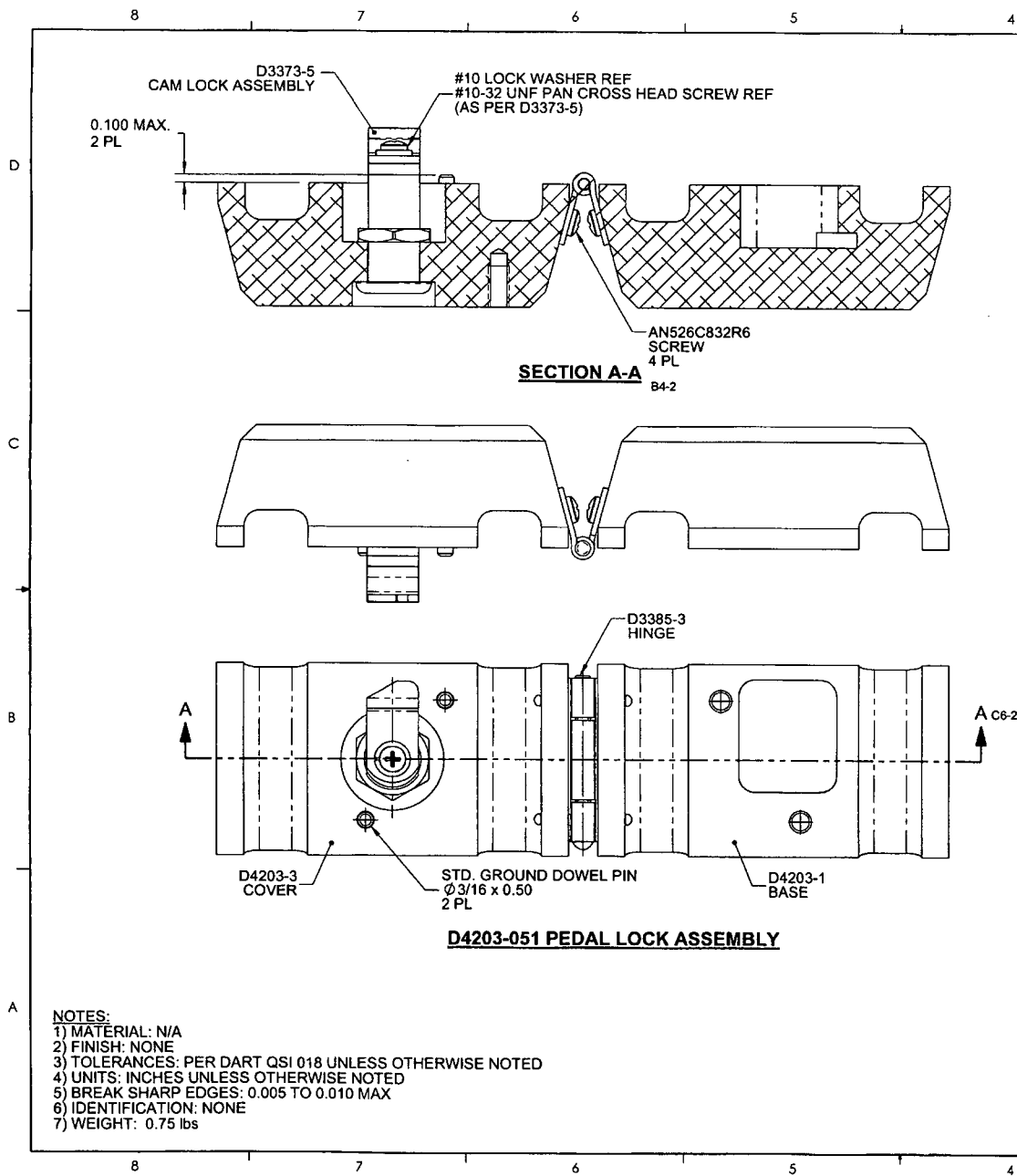
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



62351

**RELEASED**  
2010-10-15

DESIGN	MP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	MP		
CHECKED	MP	DRAWING NO. <b>D4203</b>	REV. A
MFG. APPR.	MP		SHEET 2 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	<b>PEDAL LOCK</b>	NTS
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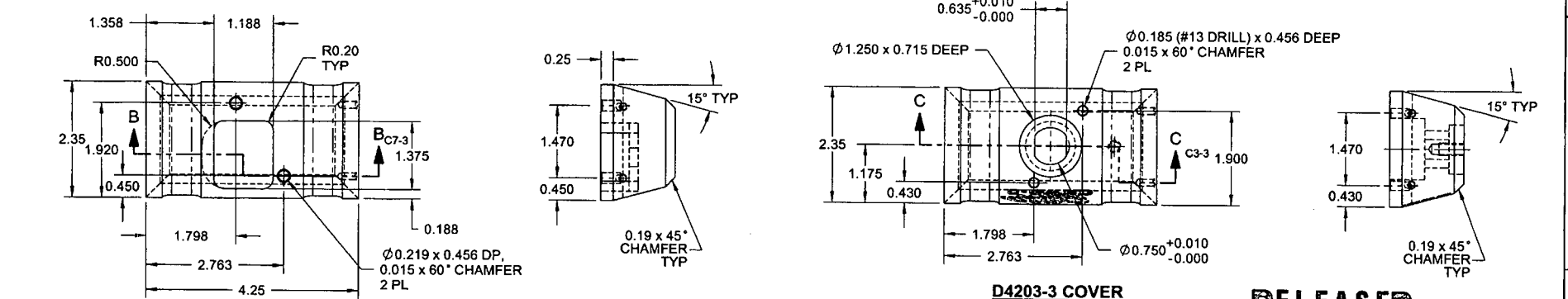
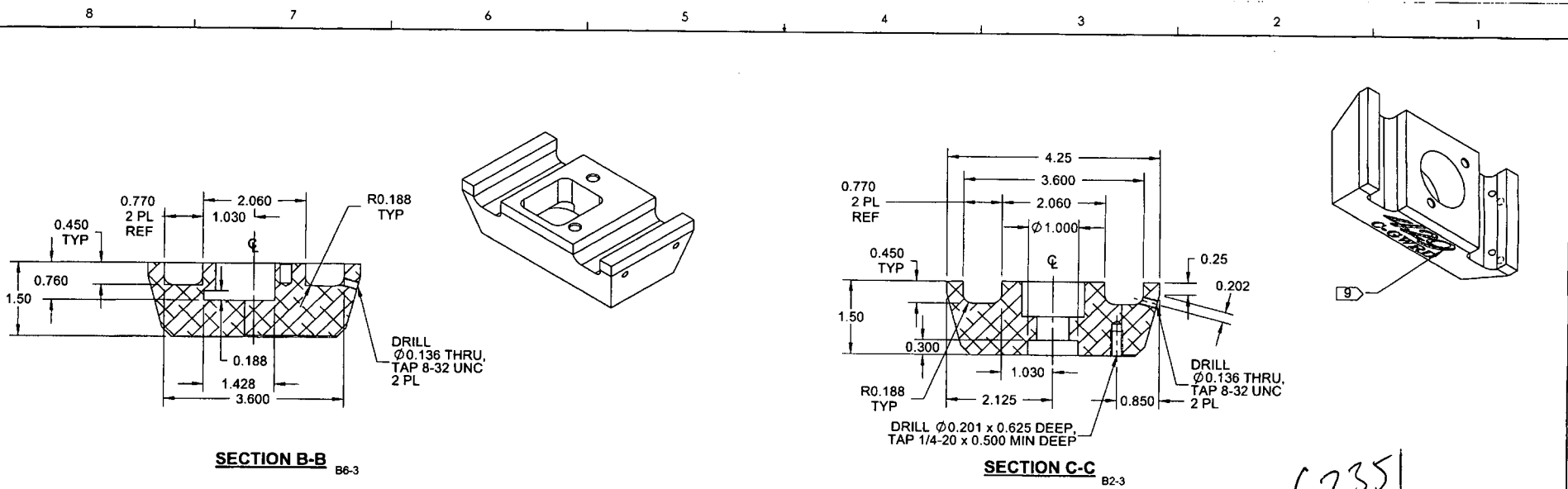
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



- NOTES:**
- 1) MATERIAL: 6061-T6/T651 PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221 REF. DART SPEC. M6061T6B
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) ALL DIMENSIONS ARE IN INCHES
  - 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: N/A
  - 8) MASK INSIDE HOLES PRIOR TO FINISH
  - 9) ENGRAVE LOGO AND AIRCRAFT ID PER D4203-3.SLDPRT

DESIGN	MP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	MP		
CHECKED	MP	DRAWING NO.	REV. A
MFG. APPR.	<i>MB</i>	<b>D4203</b>	SHEET 3 OF 3
APPROVED	<i>MB</i>	TITLE	SCALE
DE APPR.	<i>MB</i>	<b>PEDAL LOCK</b>	NTS
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries